

54466 Derev

Work Order ID 53867



Page 1

November 20, 2009 12:56:35 PM

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Plan ID:

Required Date: 08/12/2009 Req Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: *RS*

Date: 09/11/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DC

DOCUMENT CONTROL

Document Control

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

8
02/12/08DSI 9490
per ECN 09-702

HJ BG 09/11/23

53867

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side).

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297"

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ Aluminum Rod

☒ m112507

10-Grind welds flush as per Dwg D2750

BE 09/11/24

- AWM 9-11-24

BE 09/11/24

AWM 9-11-24

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- scribe batch #.

-AUM 9-11-24

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

27 80916/24

Quality Control



130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) 80916/24

Quality Control



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 - AUM 9-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 53867

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Item Name: Skidtube RH

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Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Run Start

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 09/11/30

12-Deburr holes

- ALM 9-11-30

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

27 S 01/12/01

⑧

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

27 S 01/12/01

+1

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

M 09/12/09

(X) 0

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 11/21/08

Memo

0.00

1/11/09-1

(X) 0

Powder Coating

START TIME 11:00
OVEN TEMPERATURE: 320°
FINISH TIME: 11:30

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

M 09/12/09

(X) 0

Quality Control

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 53867

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Item ID: D350-636-012

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Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220



HandFinish

HandFinishing

0.00

Memo

0.00

=> M 09/12/02

①

②

Hand Finishing

Install inserts as per dwg D2750

230



HandFinish

HandFinishing

0.00

Memo

0.00

=> M 09/12/02

①

②

Hand Finishing

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"
batch: 0143-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 241

BATCH: M112345EXP DATE: 10/09

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

✓ A/R 55-o-ring lube batch: M101223

5-Coat all exposed fasteners with "LPS Procyon"

batch: M104251

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 53867

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Item ID: D350-636-012

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Setup Start



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Stop



Item Name: Skidtube RH

Start Date: 20/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



2) 8 Oct 12/02

QC

Memo

0.00

Quality Control



250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/12/08 SP

260

QC4- 100% Inspect kits for completeness

0.00



2) 8 Oct 12/08

QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 53867

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Item Name: Skidtube RH

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Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270



Packaging

0.00

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

H

280



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

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Work Order ID: 53867



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------	---------------------	------------	----------	------------------	---------------	--------------	-----------------	-------------	-----------------------	------------	-------------	--------

ALS4-1032-225		Purchased	No			220	Each	7,324.000	38.0000			
---------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7324

107441

16

110768

7308

338

09/12/02

AN3C5A

Purchased

No

230

Each

1,118.000 34.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1118

111424

8

111707

69

112314

1

112641

440

113121

300

113149

300

34

09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A  BOLT		Purchased	No			230	Each	904.0000	4.0000			

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

904

904

x4 M 09/12/02

AN6C44A



BOLT

Purchased

No

111982

230

Each

180.0000

4.0000

Warehouse
Location
OFFSHORE
FG

Loc Qty

Loc Code

103964

Main Warehouse

ST

2

2

178

110105

4

110155

14

110665

1

111605

50

111649

50

112720

9

113121

50

x4 M 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN8C35A

Purchased

No

230

Each

144.0000

1.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

144

102180

1

106896

1

110105

48

110847

94

AN960C10L

Purchased

No

230

Each

2,658.000

38.0000



washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

2558

112116

548

112612

1010

112933

1000

x 41 09/12/02

x 38 41 09/12/02

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube RH


Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L  WASHER		Purchased	No			230	Each	260.0000	1.0000			



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	260	
104093	2	
107520	4	
110139	29	
<u>110372</u>	10	
110584	100	
111424	115	

 x1 20/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	402.0000	8.0000			

Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	88	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	6	
43754	2	
44893	33	
45556	1	
48278	29	
Main Warehouse		
ST46	314	
51537	70	
51910	63	
52311	181	

✓ 8 11 09/12/02

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3488-042RevB Manufactured No



Blade Fitting Assembly, RH

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	19	
	29043	1	
	52666	18	

D3492-041RevC Manufactured No



Plug Assembly

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	140	
	51584	140	

D3492-043RevC Manufactured No



Plug Assembly

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	84	
	52309	84	

x1 M 09/12/02

x8 M 09/12/02

x8 M 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25RevB		Manufactured	No			230	Each	24.0000	1.0000			

Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

14

51663

1

51927

13

Main Warehouse

ST

10

52589

10

D3536-25RevA

Manufactured

No

230

Each

23.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP10

18

51607

18

Main Warehouse

ST

5

45569

1

47011

2

47526

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-1RevC		Manufactured	No			230	Each	198.0000	3.0000			
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Wearpad

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	196	
51678	91	
51679	105	

x3 M 09/12/02

D3631-1RevA

Manufactured No



Washer

230	Each	221.0000	8.0000
-----	------	----------	--------

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	221	
38139	6	
45353	16	
47437	1	
52693	198	

x3 M 09/12/02

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Start Date: 20/11/2009

Required Date: 08/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3791-1RevA		Manufactured	No			230	Each	19.0000	1.0000			
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Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 7

51610 7

Main Warehouse

ST 12

(51909) 12

D3793-1RevA		Manufactured	No			230	Each	27.0000	1.0000			
-------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 27

40551 1

51597 16

(51906) 10

xl ME 09/12/02

xl ME 09/12/02

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3793-3RevA

Manufactured

No

230

Each

23.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

51592

12

51903

11

D3794-1RevA

Manufactured

No

230

Each

22.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

12

51928

12

Main Warehouse

ST

10

46530

1

47212

2

51668

7

xl 09/12/09

xl 09/12/09

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA		Manufactured	No			230	Each	28.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 24

51598 12

51907 12

Main Warehouse

ST 4

46531 2

47440 1

47722 1

MS21043-6

Purchased

No

230

Each

1,040.000

4.0000



NUT

X1 M 09/12/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST 1040

11424 40

112314 1000

X4 M 09/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8  NUT		Purchased	No			230	Each	72.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	72	
110584	5	
111424	2	
112492	15	
113149	50	

x1 41 09/12/02

NAS1515H3L  WASHER		Purchased	No			230	Each	266.0000	4.0000			
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<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	226	
110450	2	
111819	224	

x4 42 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1611-010

Purchased

No

230

Each

338.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

338

110715

44

110915

294

NAS1611-013

Purchased

No

230

Each

138.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

138

106513

11

111424

20

111758

107

11/09/12/02 PTO =>

ys 11/09/12/02

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Dart Aerospace Ltd

W/O: 53867		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/12/02		Replace NAS1611-011 "O" Rings FOR P254-3 B 52562	JA	09/12/02	(X8)	U	S 09/12/02

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A  BOLT		Purchased	No			250	Each	114.0000	2.0000			

9/11/08 SV

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	114	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
111684	4	
112720	50	

2

AN960C816L

Purchased

No

250

Each

260.0000

2.0000

WASHER

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	260	
104093	2	
107520	4	
110139	29	
110372	10	
110584	100	
111424	115	

2

9/11/08 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2741RevC

Manufactured

No

250

Each

53.0000

1.0000



Blade, 350 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

20770

0

45320

1

47113

12

51931

40

9/12/7 SP

D3493-1RevA

Manufactured

No

250

Each

69.0000

2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

69

44902

2

47710

67

9/12/7 SP

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:


Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

8 D3532-1RevA		Manufactured	No			250	Each	93.0000	2.0000			
												
Spacer												



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	93	

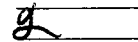
9/12/17 SP

5 MS21083C8		Purchased	No			250	Each	72.0000	2.0000			
												
NUT												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	72	
110584	5	
111424	2	
112492	15	
113149	50	



9/12/17 SY



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1515H8L Purchased No



WASHER

D3672-B
per ENCLOS. 702
u

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

81

107581

34

108964

1

111650

46

D2600-3-BENTRevD1 Manufactured No



Extrusion Bent

D2744RevC Manufactured No



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

67

44892

1

47488

30

51922

36

2.0000



9/12/8 sl

B112142 2 sl

B54963

1.0000



2

1.0000



252346

BE 09/11/23

1.0000



1

BE 09/11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	1.0000	1.0000			
												
350 I Beam												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47124

B 53900

1 11/11/25

D2743RevB

Manufactured

No

160

Each

355.0000

8.0000



Crossbolt Spacer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

110

50281

50

51913

60

Main Warehouse

ST

245

44891

2

45555

57

48275

1

52310

185

B

BE 09/11/30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53867

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 20/11/2009

Required Date: 08/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3490-3RevA

Manufactured

No

160

Each

65.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

45560

1

48276

31

51930

33

D3490-1RevA

Manufactured

No

160

Each

112.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112

45338

2

47657

22

48277

48

51932

40

4

BE 09/11/30

4

BE 09/11/30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

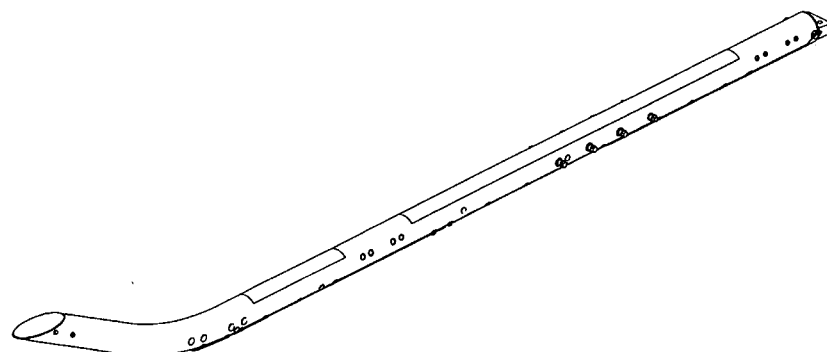
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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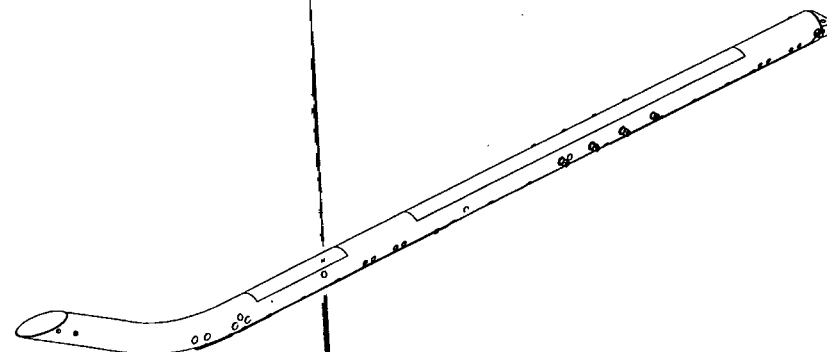
09-11-20

RELEASED

F	INCORPORATE DSI 0413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT	DART AEROSPACE USA, INC.	
DRAWN	PORT	PORT HADLOCK, WA	
CHECKED	ALB	DRAWING NO.	REV. F
MFG. APPR.	ALB	D2750	SHEET 1 OF 11
APPROVED	ALB	TITLE	SCALE
DE APPR.	ALB	350 SKIDTUBE ASSEMBLY	NTS
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

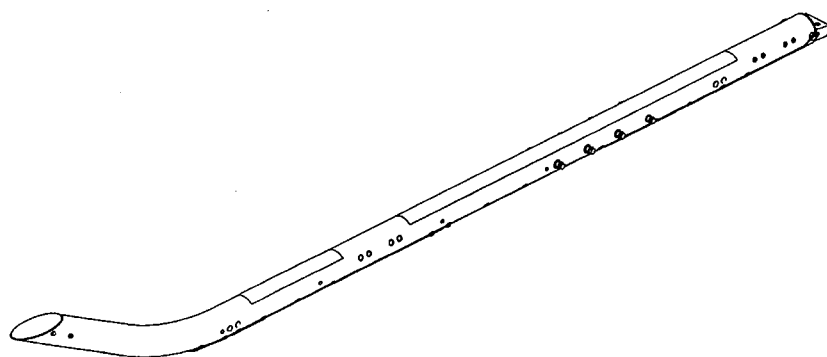


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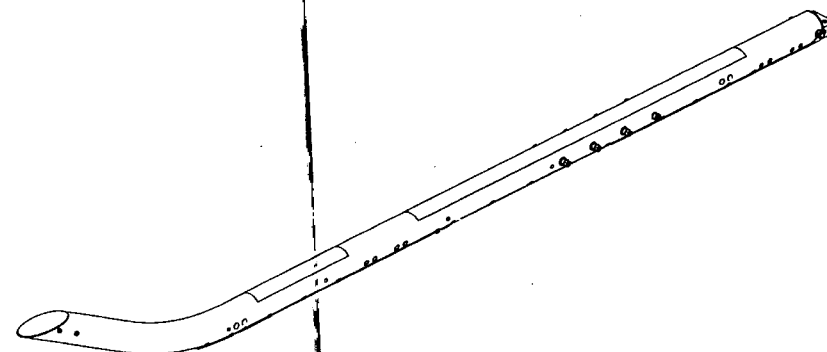
RELEASED
88-09-22/17

W/0 53867

DESIGN	<i>PC</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>AM</i>	PORT HADLOCK, WA	
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MFG. APPR.	<i>SA</i>	SHEET 2 OF 11	
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

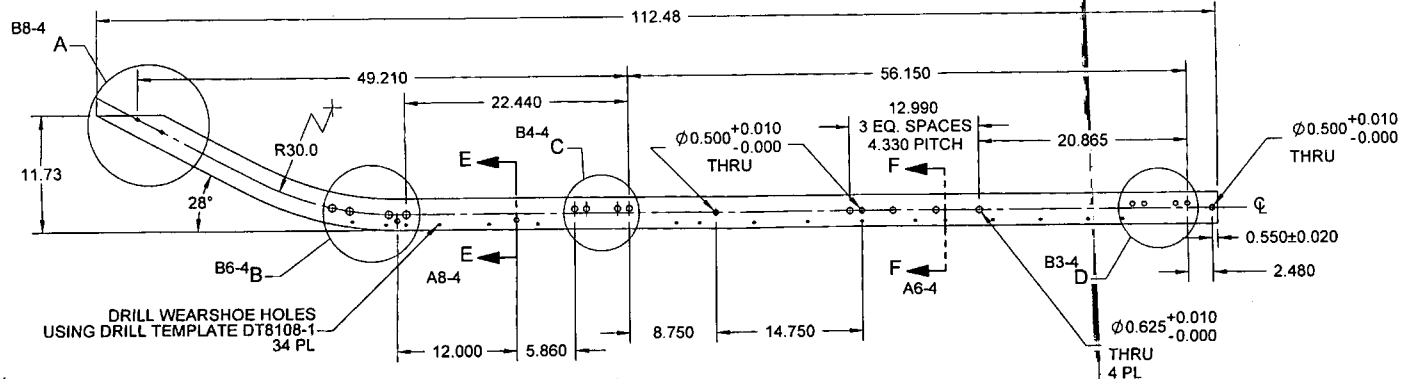


D2750-044 350 SKIDTUBE ASSEMBLY, RH

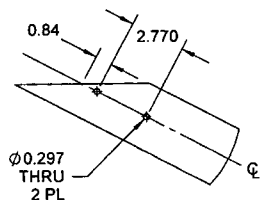
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68-9-22-1-11

W10 53867

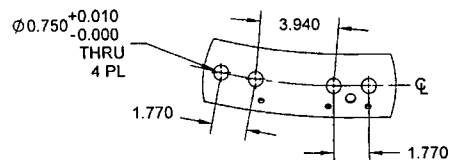
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CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
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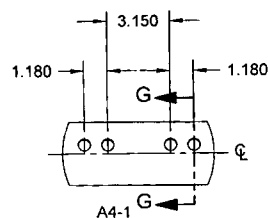
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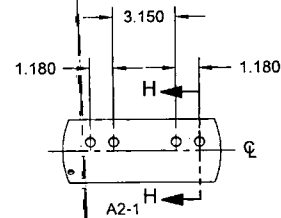
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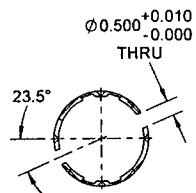
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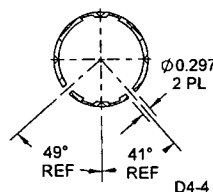
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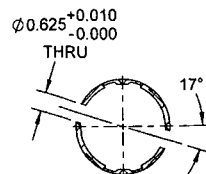
DETAIL D
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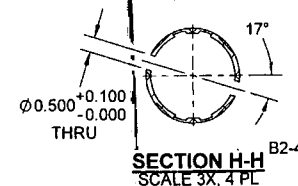
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

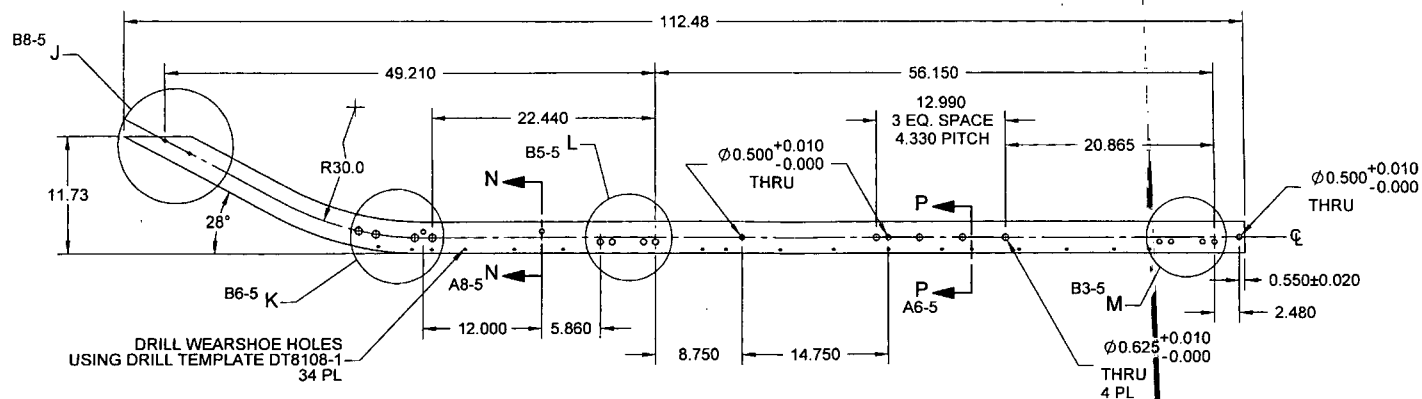


SECTION H-H
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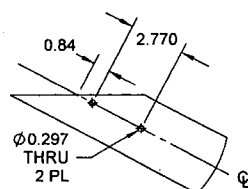
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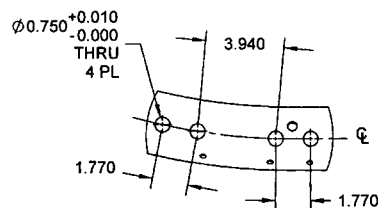
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MFG. APPR.			SHEET 4 OF 11
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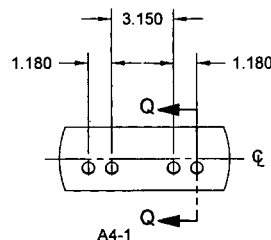
D2750-2 RH SKIDTUBE



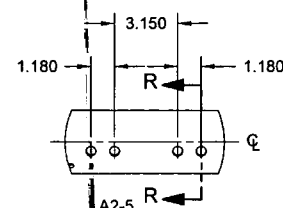
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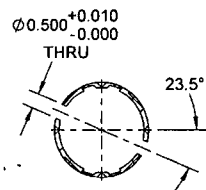
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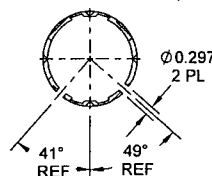
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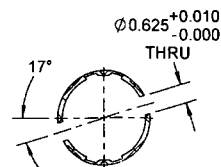
DETAIL M
SCALE 2X



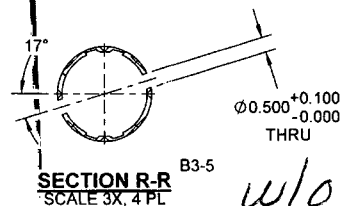
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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7

6

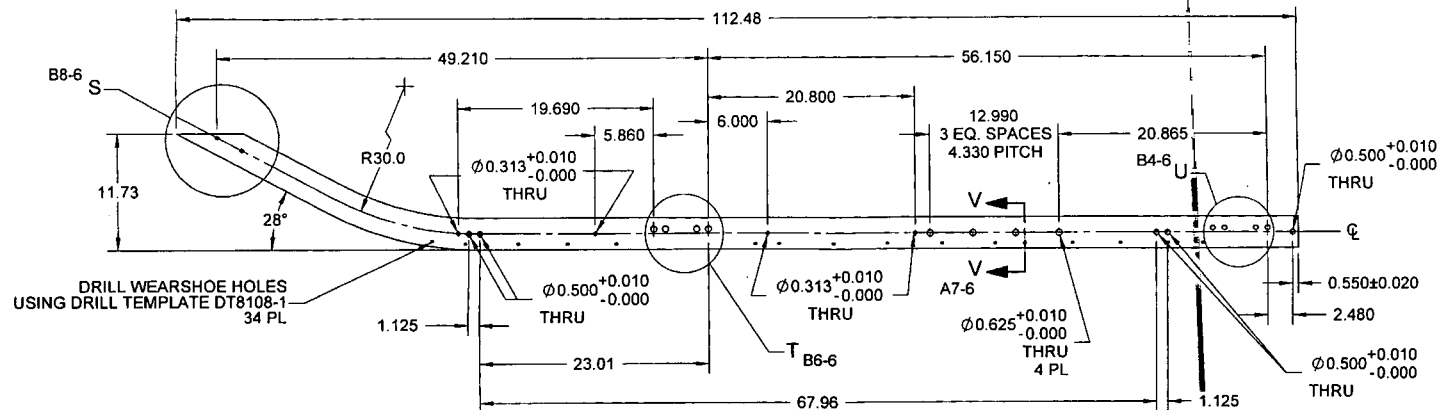
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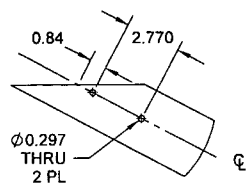
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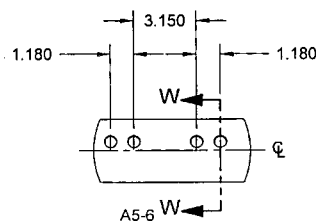
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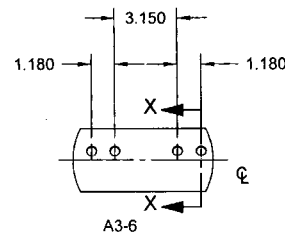
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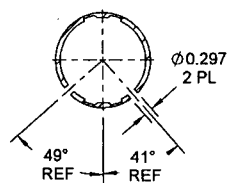
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SCALE 2X
D8-6



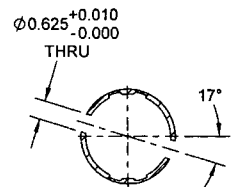
DETAIL T
SCALE 2X
C5-6



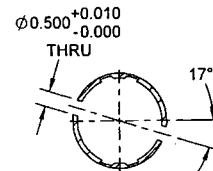
DETAIL U
SCALE 2X
D3-6



SECTION V-V
SCALE 3X, 17 PL
C4-6



SECTION W-W
SCALE 3X, 4 PL
B6-6



SECTION X-X
SCALE 3X, 4 PL
B4-6

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APPROVED		TITLE	SCALE
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7

6

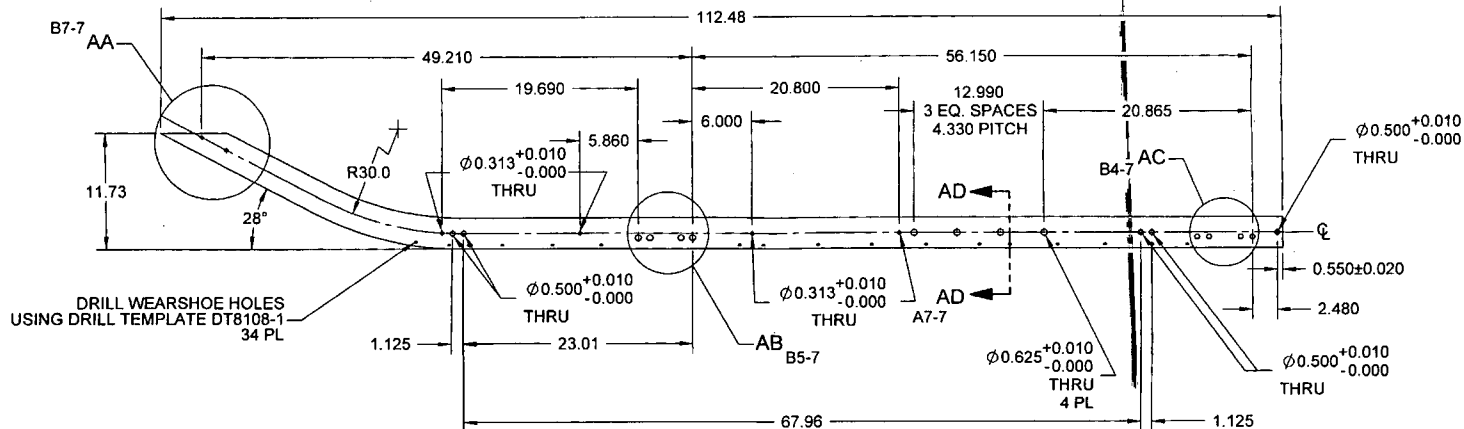
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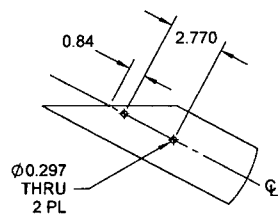
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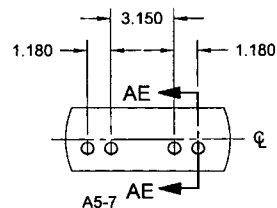
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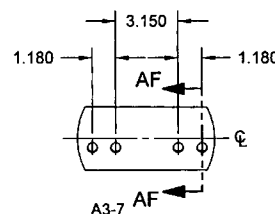
D2750-4 RH SKIDTUBE



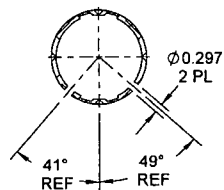
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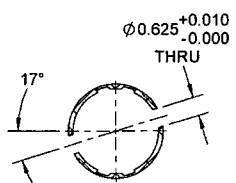
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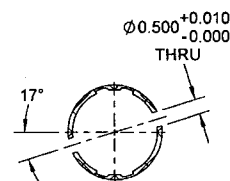
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

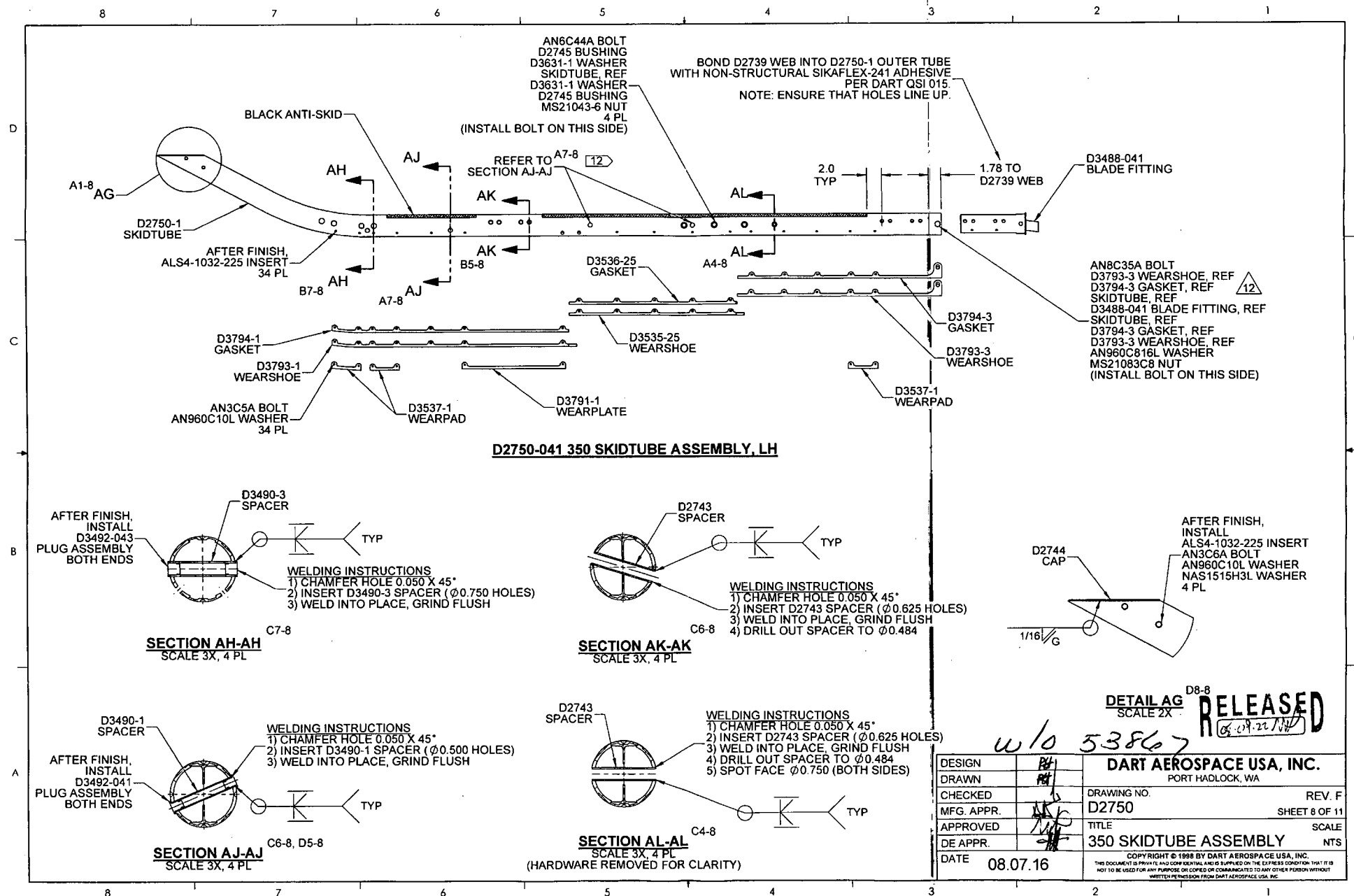


SECTION AF-AF
SCALE 3X, 4 PL

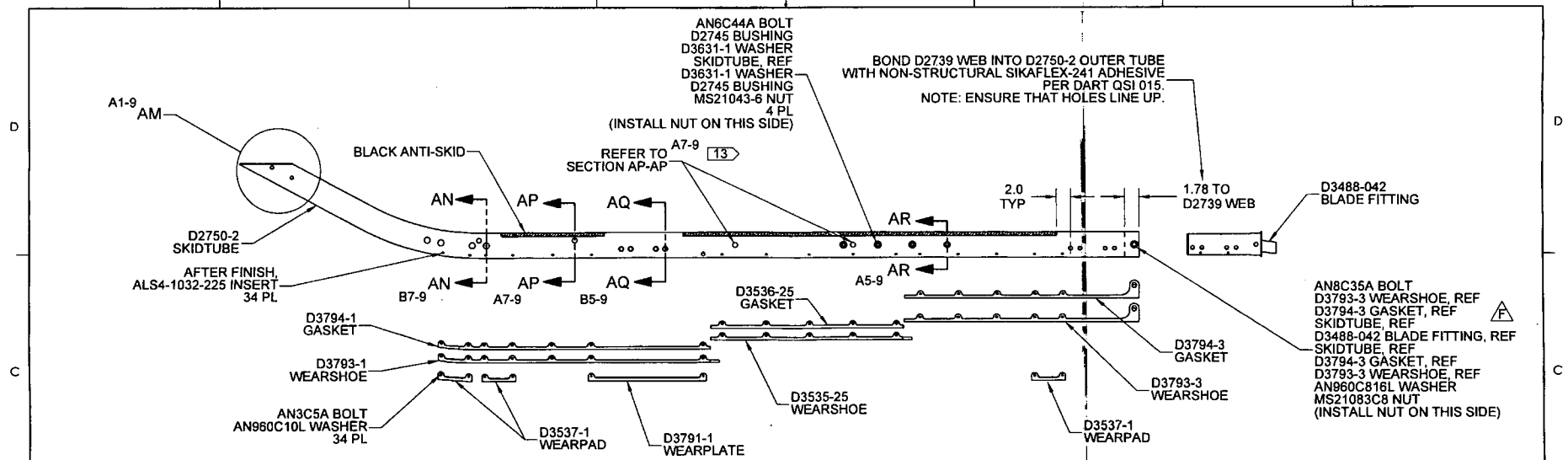
RELEASED
06-02-78

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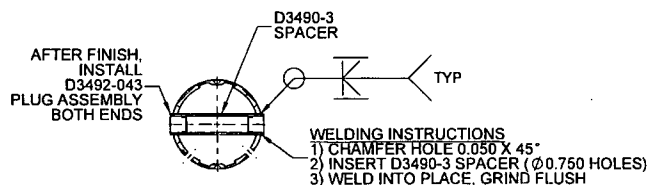
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DRAWN	PA	PORT HADLOCK, WA	
CHECKED	5	DRAWING NO.	REV. F
MFG. APPR.	5	D2750	SHEET 7 OF 11
APPROVED	MD	TITLE	SCALE
DE APPR.	11	350 SKIDTUBE ASSEMBLY	NTS
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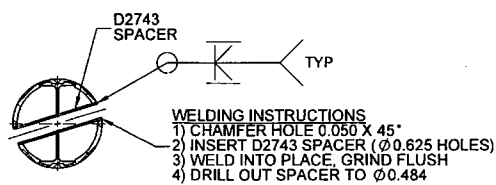
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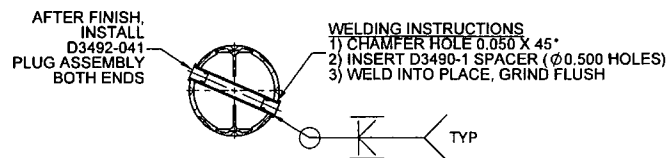
D2750-042 350 SKIDTUBE ASSEMBLY, RH



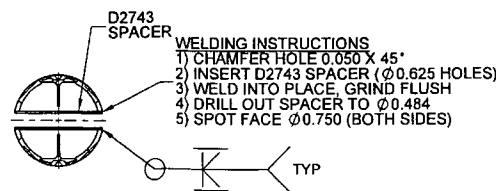
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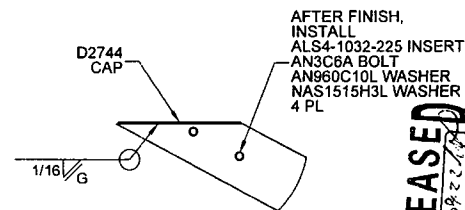
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SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL



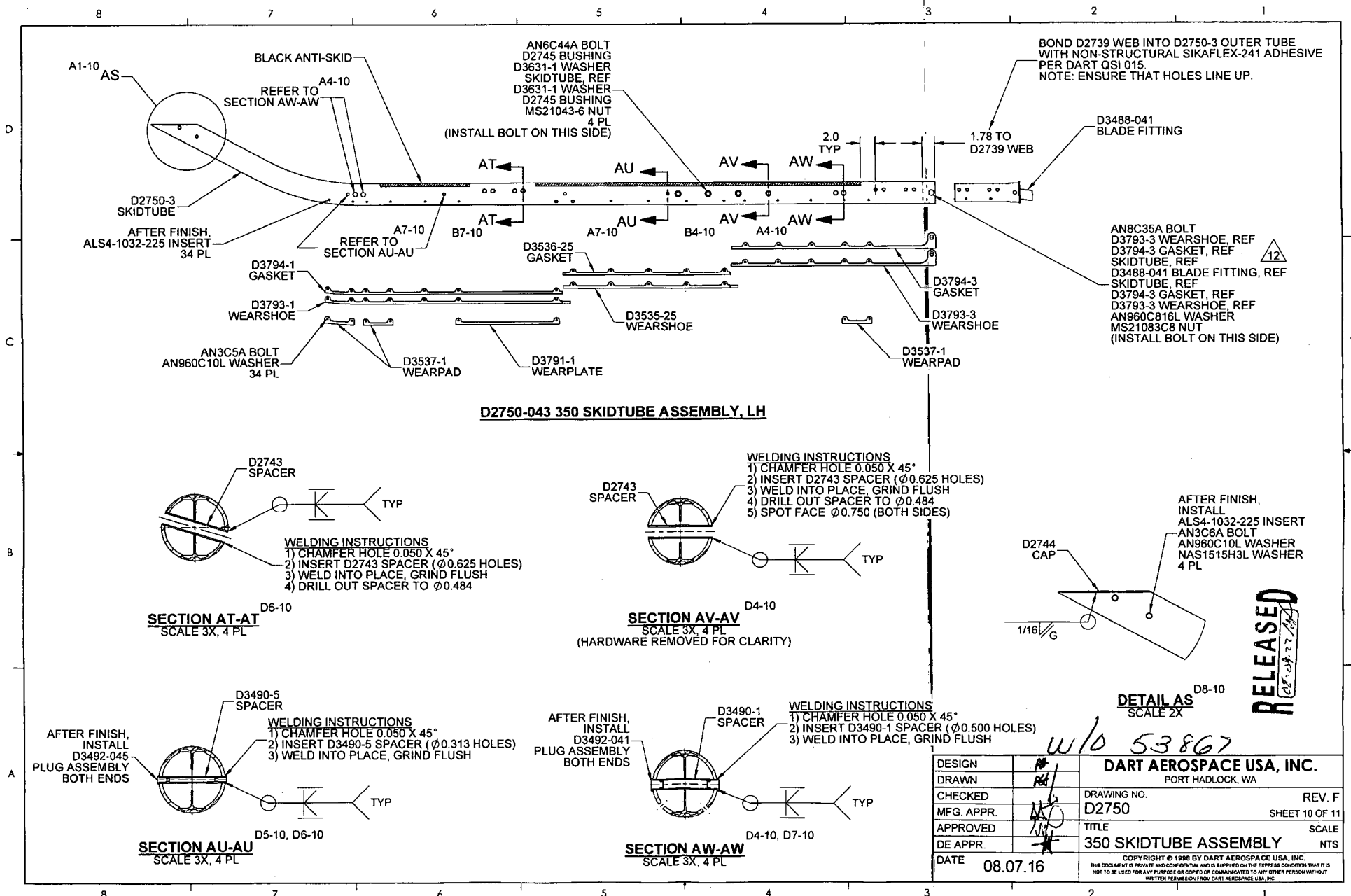
SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 8 OF 11
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08-09-2016



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CHECKED		DRAWING NO.	REV. F
MFG. APPR.	W/ID 53867	D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.	W/ID 53867	350 SKIDTUBE ASSEMBLY	NTS
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RELEASED
08-07-16

NO. 213

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 851620
Part number: 1350-636-Q12
Description: 350 SKIDHUB
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Dard Date of Test Coupon 09/10/22

Welder Barclay Elliott Date of Test Coupon 09/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld